

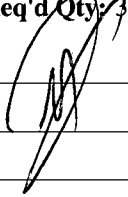
Work Order ID 163118

Wednesday, June 21, 2017 3:10:04 PM

163118

Page 1

Item ID: D5350-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Cross Beam Assembly
 Start Date: 7/10/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan:  Date: JUN 21 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5350	D

100	Cut blanks as per folio	0.00							DAS 14 9-89
100						3	0		17/07/14
Bandsaw	Memo	0.25							
Jeaspa Bandsaw	Cut blank at 69.300"								

110		0.00							DAS 14 9-89
110						3	0		17/07/15
HAAS 4	Memo	4.25							
HAAS CNC vertical machine #4	1-Machine per folio FB447 (D5350-1) DWG REV: <u>D</u> FOLIO REV: <u>AA</u>								

2- Deburr and break all sharp edge as per dwg.

DAS
44/17-07-17
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Wednesday, June 21, 2017 3:10:04 PM

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17/07/19

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Work Order update only ☐

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Hand Finishing

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9-89
JUL 20 201

(X3) ~~0~~ 20120224
BEB

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**WORK ORDER NON-CONFORMANCE / UPDATE**

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
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Work Order ID 163118

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163118

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Item ID: D5350-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Cross Beam Assembly
Start Date: 7/10/2017 Start Qty: 3.00 ***3*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.03				3	0	17-07-24.	3389
190 *190* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m 138014.</i> Memo MASK HOLES AS PER NOTE 8 SHEET 3 START TIME: <u>9:25.</u> OVEN TEMPERATURE: <u>200°</u> FINISH TIME: <u>9:55.</u>	0.00 0.48				3	0	17-07-25.	3389
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				3x		17/07/25	DAS 36 389

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163118

Page 5

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/10/2017 **Start Qty:** 3.00 ***3***

Cust Item ID:

Required Date: 7/20/2017 **Req'd Qty:** 3.00 ***3***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

210

1.75

Small Fab

Memo

ASSEMBLE AS PER DWG. D5350-041 (see notes)

Small Fab

2

6

JUL 25 2017

DAS
19
9-80

0.00

220

0.06

OC

Memo

Quality Control

1

DAS
38
9-89
JUL 26 2017

0.00

230

0.03

Packaging

Memo

Packaging

2

9-80 6 DAS

JUL 26 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
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Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐		Past Due ☐																							

Work Order ID 163118

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163118

Page 6

Item ID: D5350-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Cross Beam Assembly

Start Date: 7/10/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.30

Quality Control

**DAS
21
9-89**

JUL 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 163118

163118

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Cross Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C
16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09
DWG REV.c DD VERF:JLM IPP REV:E DWG. REV.D
17/04/11 JFS VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CBL-1240		Purchased	No			210	f	309.3597	5.42	17.11579			
CBI -1240									**			JUL 25 2017	DAS 19 9-89
Cable													

Location

Loc Qty

Loc Code

GA

309.3597488

m136491

47.6052488

m136852

61.7545

m137684

200

2.2
15

FOR D2690-8
CUT TO 13.000"

CBL-460

Purchased

No

210

Each

178.0000

10

30

CBI -460

Loop Sleeve

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

178

m136852

10

m137339

168

6
24

FOR D2690-8

D5324-3

Manufactured

No

210

Each

64.0000

1

3

D5324-3

Bracket

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

ST164

64

161326

64

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 163118

163118

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Cross Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

D5346-3 Manufactured No

210 Each 39.0000 4 12

D5346-3

Bushing

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

ST165

39

161327

39

M6061T6B1.000X06.00

Purchased No

100 f 19.1100 5.775 18.23684

0

M6061T6B1 000X06 000

6061T6 BAR 1.00 X 6.00

**

Location

Loc Qty

Loc Code

MAT003

19.11

m130013

2.7

m134705

7.83

m137365

8.58

D5350-5

Manufactured No

210 Each 0.0000 1 3

D5350-5

Adapter

AN3-13A

Purchased No

210 Each 61.0000 2 6

AN3-13A

Bolt

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

11

m127070

11

ST349

50

m137886

50

**

JUL 25 2017

DAS
19
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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																						OTHER : _____																																									

Picklist Print

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Page 3

Work Order ID: 163118

163118

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Cross Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

MS17984-C412

Purchased

No

210

Each

23.0000

2

6

MS17984-C412

Pin, Quick Release

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

ST315

23

m136593

23

MS17984-C418

Purchased

No

210

Each

4.0000

1

3

MS17984-C418

QUICK RELEASE PIN

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

FG

1

123482

1

ST315

3

m137459

3

MS17984-C517

Purchased

No

210

Each

4.0000

2

6

MS17984-C517

Pin, Quick Release

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

4

m137528

4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : ☐																							

Picklist Print

Wednesday, June 21, 2017 3:10:04 PM

Page 4

Work Order ID: 163118

163118

Parent Item: D5350-041

D5350-041

Parent Item Name: Fwd Cross Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

210

Each

1,707.000

2

6

MS21042L3

**

JUL 25 2017

DAS
19
9-89

Nut

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136663

292

OVER007

500

m134360

0

m137886

500

ST303

734

m137495

14

m137680

720

NAS1149D0316J

Purchased

No

210

Each

691.0000

4

12

NAS1149D0316J

**

JUL 25 2017

DAS
19
9-89

Washer

Location

Loc Qty

Loc Code

ST264

691

M134502

691

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
2								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	163118
Description: Fwd Cross Beam		Part Number:	D5350-1
Inspection Dwg: D5350 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.40	±.030	.400	✓		Vern M-L-06	
1.00	±.030	1.000	✓		"	
1.20	±.030	1.200	✓		"	
2.00	±.030	2.000	✓		"	
3.15	±.030	3.150	✓		"	
37.20	±.030	37.200	✓		M-Top	
37.69	±.030	37.690	✓		"	
39.70	±.030	39.700	✓		"	
.300	±.010	.300	✓		Vern M-L-06	
.280	±.010	.283	✓		"	
.25	±.030	.250	✓		"	
12.000	±.005	12.000	✓		CAL-02	
9.06	±.030	9.060	✓		"	
3.000	±.030	3.000	✓		Vern M-L-06	
.80	±.030	.800	✓		"	
5.22	±.030	5.218	✓		"	
4.55	±.030	4.55	✓		"	
4.05	±.030	4.050	✓		"	
3.30	±.030	3.30	✓		"	
.30	±.030	.300	✓		"	
.550	±.010	.557	✓		"	
.225	±.010	.218	✓		"	
R.13	±.030	R.125	✓		R-L	

Measured by:	DAS 14 9-89	Audited by:	DAS 33 9-89	Preliminary Approval:	
Date:	17/02/15	Date:	17/07/19	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

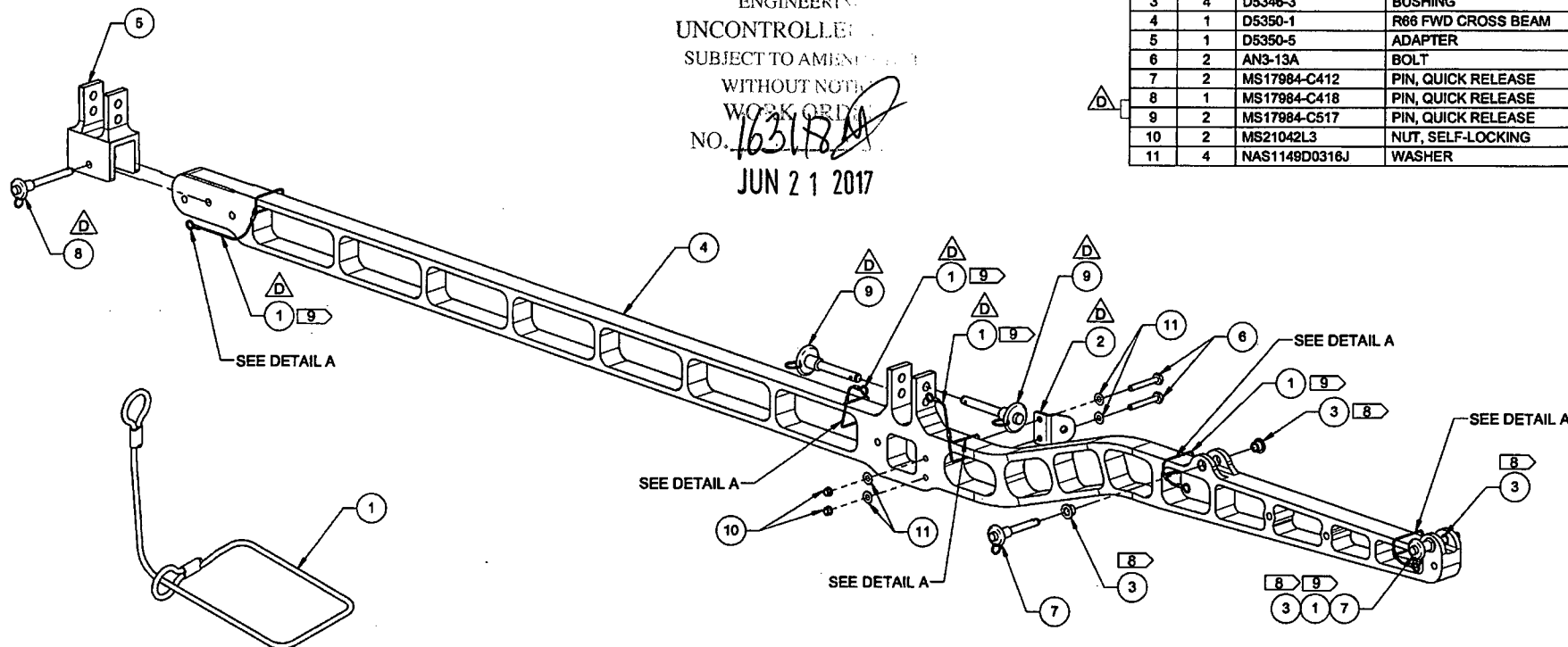
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 16318

JUN 21 2017

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5350-041	R66 FWD CROSS BEAM ASSEMBLY
1	5	D2690-8	LANYARD ASSEMBLY
2	1	D5324-3	BRACKET
3	4	D5346-3	BUSHING
4	1	D5350-1	R66 FWD CROSS BEAM
5	1	D5350-5	ADAPTER
6	2	AN3-13A	BOLT
7	2	MS17984-C412	PIN, QUICK RELEASE
8	1	MS17984-C418	PIN, QUICK RELEASE
9	2	MS17984-C517	PIN, QUICK RELEASE
10	2	MS21042L3	NUT, SELF-LOCKING
11	4	NAS1148D0316J	WASHER



DETAIL A

D5350-041 R66 FWD CROSS BEAM ASSEMBLY

D	REDESIGN -1/3/041/043 (ZN A4-1, A4-2, A4-3, A4-4); Ø0.323 WAS Ø0.318 (ZN C1-3, C1-4, D3-5); REVISE BOM & NOTE 8 (ZN A8-1, D3-1, A8-2, D3-2,); ADDED DETAIL A & B (ZN B7-1, B7-2)	RF	17.02.09
C	REDESIGN -1/3/041/043 (ZN A4-1, A4-2, A4-3, A4-4); ADDED -8 (ZN A4-5) & NOTE 10 & 11 (ZN A8-3, A8-4); REVISE BOMs ZN (D3-1, D3-2)	RF	18.11.18
B	REDESIGN -1/3/041/043 (ZN A4-1, A4-2, A4-3, A4-4)	RF	18.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	17.02.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5350
REV. D
SHEET 1 OF 6
SCALE
NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 5.96 lbs
 - 8) PRESS FIT D5346-3 INTO D5350-1
 - 9) ASSEMBLE D2690-8 WITH MS17984-C412/C418/C517 AS SHOWN

RELEASED
2017-03-22
ECN 17-355

